Rust

Work Order ID 107369

107369

September-23-13 11:49:24 AM

Item ID: D4003-11 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Vent Pipe - Tank

Start Date: 9/23/13 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 9/23/13 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLS **Date:** 13-09-25 **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4003 / Revision Nbr: A									
100		0.00							FF
100						4			13-12-17
Small Fab	**Memo**	0.00							
Small Fab	1- Cut tube xxx" long 2- Bend as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110						4			
QC	**Memo**	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						4			13-12-18
HandFinish	**Memo**	0.00							
Hand Finishing									

DAS 27 9-89 B 12 18

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D4003-11 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Vent Pipe - Tank

Start Date: 9/23/13 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 9/23/13 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish DAS 27 9-89	0.00				4			
	Memo	0.00 B/12/18							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: S/195	0.00				4X		13-12-19	DAS 26 9-89
	Memo	0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00				Rm 13/12/30			
	Memo	0.00							

13-12-20

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

September-23-13 11:49:24 AM

Work Order ID: 107369

Parent Item: D4003-11

Parent Item Name: Vent Pipe - Tank

Start Date: 9/23/13 **Required Date:** 9/23/13

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP rev A 10.01.12 new issue prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.035 6061-T6 RD Tube .500 x.035W		Purchased	No			100	f	108.0300	1.97	**7.88**			FF 13-12-17

Location	Loc Qty	Loc Code	
MAT014 127417	108.03		7.88
121848	81.68		
4692	26.35		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

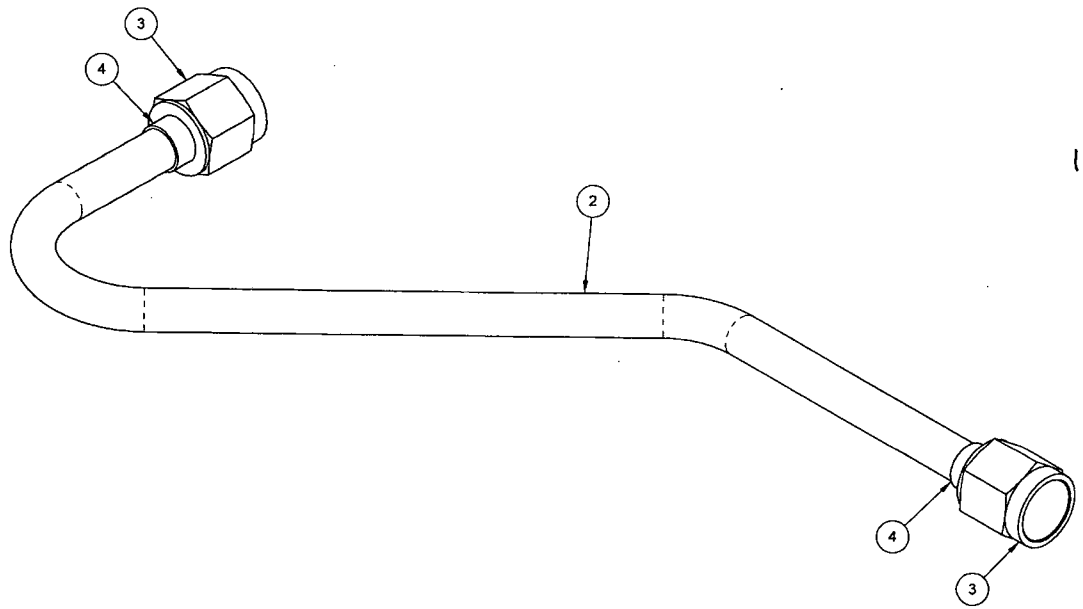
Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
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- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
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- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-047	FUEL PUMP INLET PIPE	JCA-M47-2-16
2	1	D4003-7	FUEL INLET PIPE	
3	2	AN818-6D	NUT	
4	2	MS20819-6D	SLEEVE	



107369.MCJ
13-09-25

RELEASED
2010-05-05
MP

D4003-047 FUEL PUMP INLET PIPE

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-047" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.07 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		10.02.05

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.02.05

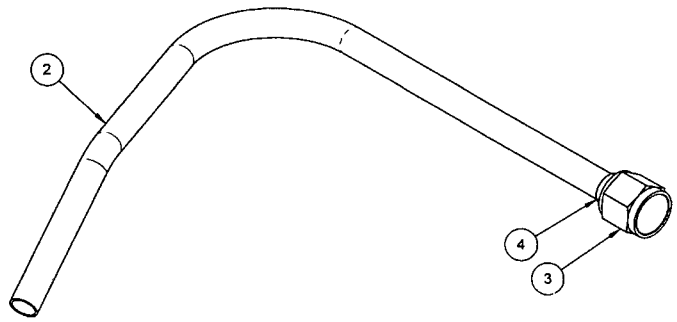
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4003 REV. A
SHEET 1 OF 9
TITLE LINE
SCALE NTS

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107369

ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-049	TANK VENT LINE ASSEMBLY	JCA-M47-2-17
2	1	D4003-9	VENT LINE	
3	1	AN818-8D	NUT	
4	1	MS20819-8D	SLEEVE	



D4003-049 TANK VENT LINE ASSEMBLY

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.11 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.02.05

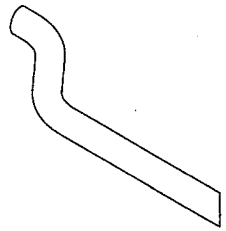
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

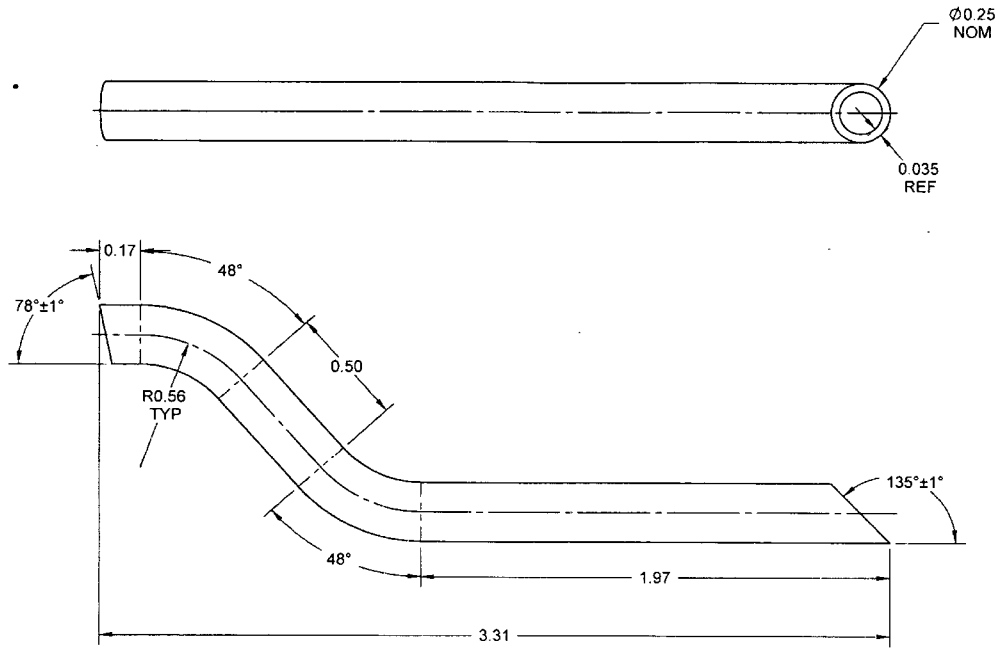
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	SHEET 2 OF 9
TITLE LINE	SCALE NTS

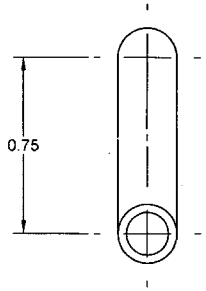
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107369

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-1	REF JCA-M47-1-06







RELEASED
2010 -05- 05

D4003-1 INTERNAL DRAIN LINE, AFT

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.25 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC 6061T6T0.250W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.02.05

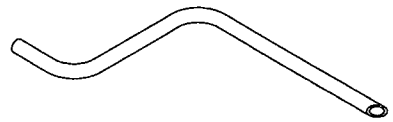
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

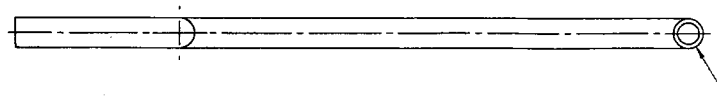
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D4003	SHEET 3 OF 9
TITLE	SCALE
LINE	NTS

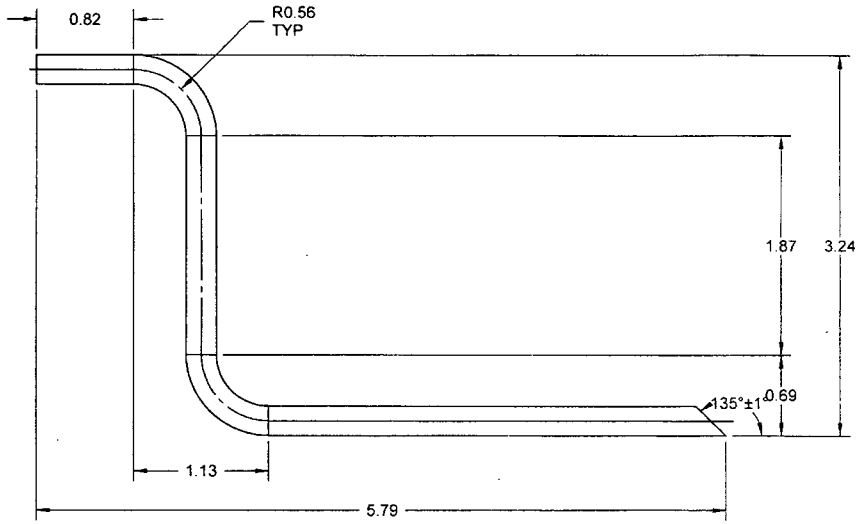
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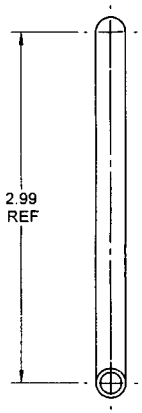
107369

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-3	REF JCA-M47-1-15









D4003-3 INTERNAL DRAIN LINE, FWD

RELEASED
2010 -05- 05
MP

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.25 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC 6061T6T0.250W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.02.05

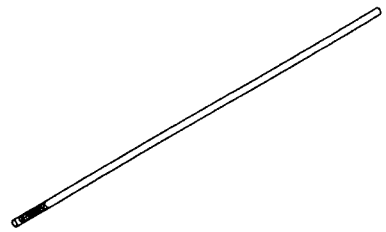
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

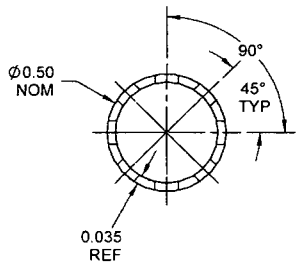
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	SHEET 4 OF 9
TITLE LINE	SCALE NTS

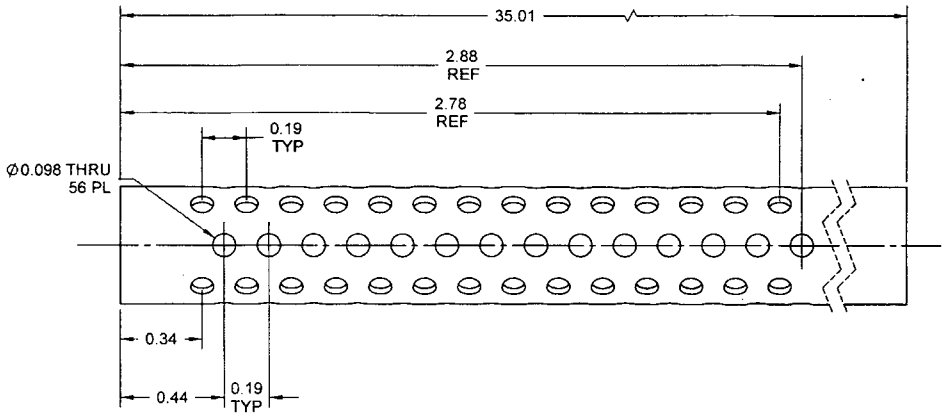
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107369

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-5	REF JCA-M47-1-10







D4003-5 FUEL PICK UP LINE

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
REF WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DAT SPEC M6061T6T0.500W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.17 lbs

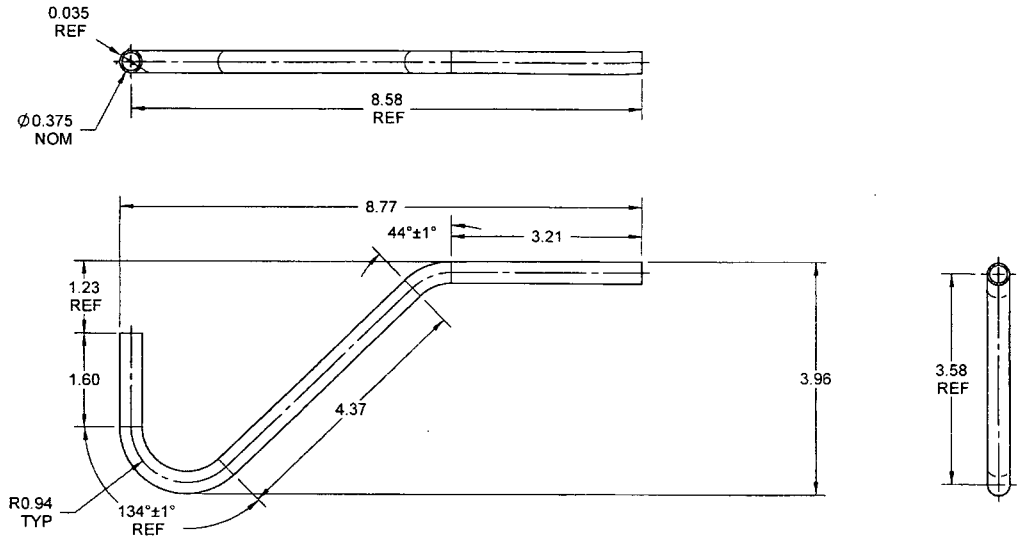
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4003 — REV. A
MFG. APPR.		SHEET 5 OF 9
APPROVED		TITLE: LINE — SCALE: NTS
DE APPR.		
DATE 10.02.05		

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107369

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-7	REF JCA-M47-2-16





D4003-7 FUEL INLET PIPE

RELEASED
2010 -05- 05

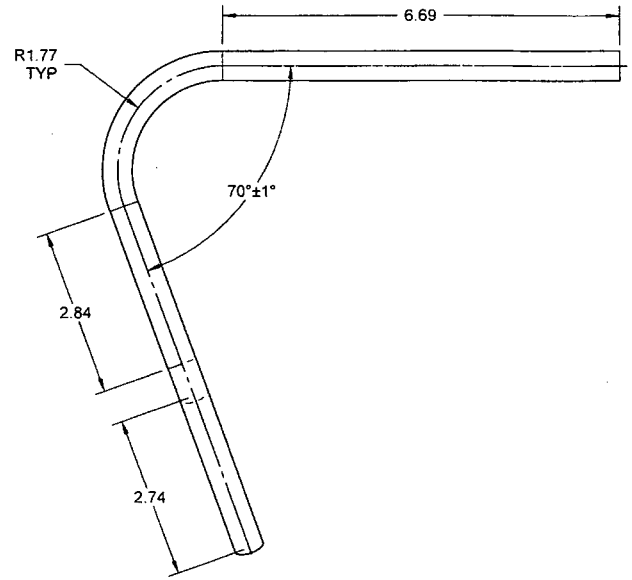
NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.375 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T0.375W.035
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.04 lbs

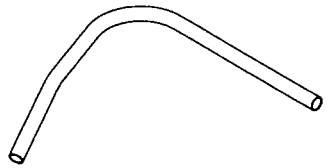
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4003 REV. A
MFG. APPR.		SHEET 6 OF 9
APPROVED		TITLE LINE SCALE NTS
DE APPR.		
DATE 10.02.05		

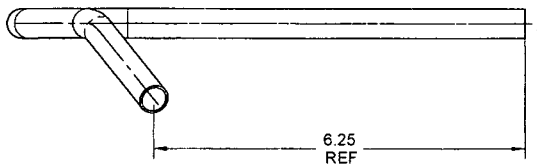
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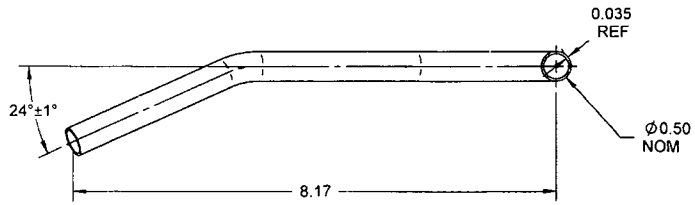
107369

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-9	REF JCA-M47-2-17









D4003-9 VENT LINE

RELEASED
2010 -05- 05

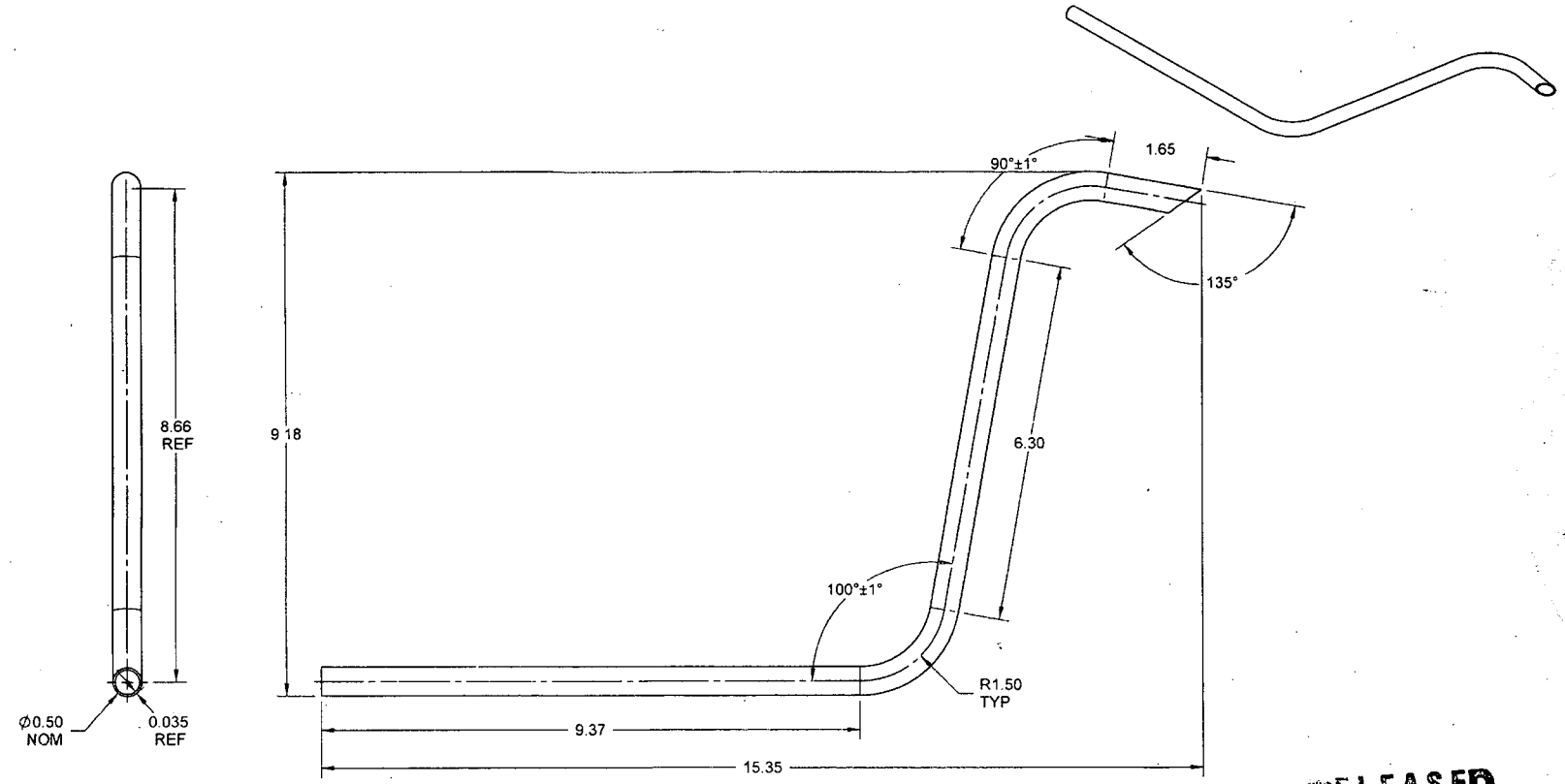
NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4003 — REV. A
MFG. APPR.		SHEET 7 OF 9
APPROVED		TITLE: LINE — SCALE: NTS
DE APPR.		
DATE	10.02.05	

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107369

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-11	JCA-M47-2-21



D4003-11 VENT PIPE - TANK

RELEASED
2010 -05- 05
MP

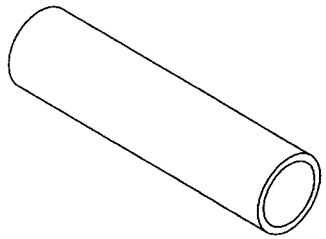
NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-11" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.11 lbs

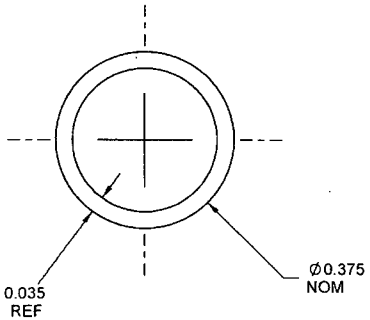
DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4003 — REV. A — SHEET 8 OF 9
MFG. APPR.		TITLE LINE — SCALE NTS
APPROVED		
DE APPR.		
DATE 10.02.05		

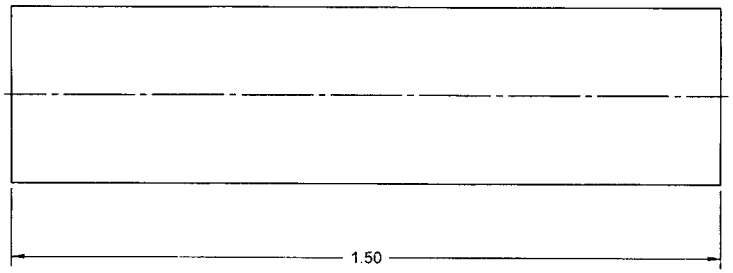
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107369

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-13	REF JCA-M47-2-22







D4003-13 FORWARD FUEL GUTTER LINE

RELEASED
2010 -05- 05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.375 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T0.375W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4003 REV. A
MFG. APPR.		SHEET 9 OF 9
APPROVED		TITLE LINE SCALE NTS
DE APPR.		
DATE 10.02.05		

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DART AEROSPACE LTD

Description:	Vent Pipe - Tank	Work Order:	107369
Inspection Drawing:	D4003	Rev: A1	Part Number: D4003-11

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.37	± 30	9.37	✓		Tape m-07	
15.35	± 30	15.35	✓		" " "	
9.18	± 30	9.18	✓		" " "	
6.30	± 30	6.30	✓		Tape measure -07	
1.65	± 30	1.65	✓		Calp 5 Feb-14	
100°	± 1°	100°	✓		Angle level 5-04	
90°	± 1°	90°	✓		square 5-Feb-16	

Measured by:	Checked By: DAS 30 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*):
FF			
Date 13-12-17	Date 13/12/17	Date 13/12/18	Date